

## Work Order ID 61889

September 9, 2010 10:06:15 AM



Page 1

Item ID: D3687-1

Accept



Setup Start



Revision ID:

Item Name: MOUNT

Stop



Start Date: 9/09/10 Start Qty: 5.00



Cust Item ID:

Required Date: 9/30/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/9/9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3687	Rev B C

100 0.00



Outsource1

Memo

0.00

CL 10/9/9 ③

Outsource process - Heat Treat

Send M174B3937X4750 For heat treating  
 to CONDITION H-900(to become M174PHH900B3937X4750)  
 FTU IN EXESS OF 190 KSI  
 FTU IN EXESS OF 170 KSI

CERTIFICATE IS REQUIRED

105 0.00



Outsource5

Memo

0.00

CL 10/9/9 ③

Outsource process - Machining

Issue P/O: 12542

Machine as per Dwg D3687

Possible Supplier: GlobusPrecision

Conformity sheet required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 61889**

Page 2

September 9, 2010 10:06:15 AM

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Start Date: 9/09/10 Start Qty: 5.00



Cust Item ID:

Required Date: 9/30/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

*Crypse (5)*

Packaging

Memo

0.00

Pb →

Packaging

Ensure certificate of conformity is attached

120



QC6- Inspect dimensions to drawing

0.00

*Dimension*

*+1 - (x) - PB next page.*

Memo

0.00

Quality Control

Check all parts w/in .150" from print

*S10W172*

*(+1)*

Check all parts w/in D3688-1, D3688-3, D3688-5  
Studs and Anodized Bolts.

124



Memo

0.00

*CZ 10/11/23 (5)*

Purchasing

Issue P/O FOR LIQUID PENETRATION  
P/O #: 12987

Certificate of conformity is required

*(+1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3873-1 PAR #: Fault Category: Supplier NCR: Yes No DQA: Date: 10/11/09  
 Resolution: re work Disposition: rework QA: N/C Closed: Date: 10/11/25

NCR: 61889		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/09	#110	Found at inspection that Qty x 5 (all) parts have th .189" hole under size (checkers with Precision Ground Pins). the .168" Pin Pins	10/11/09 10/11/09	→ Drill out .189" hole to correct size open. → Deburr	M.L. 10/11/09 M.L. 10/11/09	S 10/14/09	10/11/09 PS/1042	S 10/11/09
		RL Drilled to small from Supplier Standards Precision		→ inform checkers of issue so it can be correct in the future.				S 10/11/09
		Qty/1 has the part much slightly in size without emphasis						

NOTE: Date & initial all entries

## Work Order ID 61889

September 9, 2010 10:06:15 AM



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Item ID: D3687-1

Accept



Setup Start



Revision ID:

Item Name: MOUNT

Stop



Start Date: 9/09/10 Start Qty: 5.00



Cust Item ID:

Required Date: 9/30/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

125



Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

Packaging

Memo

0.00

ENSURE NDT RESULT IS ATTACH

→ ensure All parts are thoroughly  
cleaned before next step.

126



QC5- Inspect part completeness to step on W/O

0.00

Packaging

Memo

0.00

Quality Control

127



QC6- Inspect dimensions to drawing

0.00

QC

Quality Control

Memo

0.00

DIMENSIONAL CHECK,  
ENSURE THAT BOLT HOLES ARE CORRECT SIZE

→ 110. S10u124

→ 110. S10u124

S10u124

(46)

Issue P10 Vacuon  
attach copy of NDT results to W/O

P10.N.2987

Req'd ensure copy of NDT result  
is attached

C1011123456

W/O: 61889		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/11/09	# 125.2	Perm. chng. ADD step to ensure parts are thoroughly clean at any residue from NOT'ing	MJ	10.11.09	(4)	S 10/11/09	
			MJ	10.11.09			

Part No: 3687-1 PAR #: Fault Category: Small Fwd. NCR: Yes No DQA: Date: 10/10/09  
 Resolution: Scraps Disposition: Scraps QA: N/C Closed: T/A Date: 10/11/25

NCR: 61889		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial: Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/09	# 110	Qty #1 part had moved slightly in the vise and employee didn't notice it causing one hole to be elongated when openning up to .190".	MJ 11/09/09 QSI 042	- Script Destry no Replace	MJ 10/11/09	S 10/11/09	WJS 11/11/09 PSI 042	S 10/11/09
		R/L Process.						

NOTE: Date & initial all entries

**Work Order ID 61889**

September 9, 2010 10:06:15 AM



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Item ID: D3687-1

Accept



Setup Start



Revision ID:

Item Name: MOUNT

Stop



Start Date: 9/09/10 Start Qty: 5.00



Cust Item ID:

Required Date: 9/30/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**Sequence ID/  
Work Center ID**

130



Packaging

Packaging

**Operation  
Description**Identify as per dwg & Stock Location: 070**Set Up/  
Run Hours**

0.00

Tool ID

Tool #

**Plan  
Code**Accept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

  
10/11/25 JF


  
MK  
10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

September 9, 2010 10:06:14 AM

Page 1

Work Order ID: 61889



Parent Item: D3687-1



Parent Item Name: MOUNT

Start Date: 9/09/10

Required Date: 9/30/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 08-01-15 JLM Verified By:EC  
IPP Rev:B Added Contion H-900 JLM Verified By:DD  
C: ADDED QC6 10.09.09 JLM VERIFIED BY DD

IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M174PH-  
H900B3.937X4.750



17-4SS Bar H900-3.937x4.750

Purchased No 100 f 22.8000 0.33333 1.66665



D3687-1P



MOUNT

Purchased No 105 Each 0.0000 1 5



Location	Loc Qty	Loc Code
MAT	22.8	
110875	2	
112374	20.8	

1.66665 CL 10/9/9-

CL 10/10/26 x5

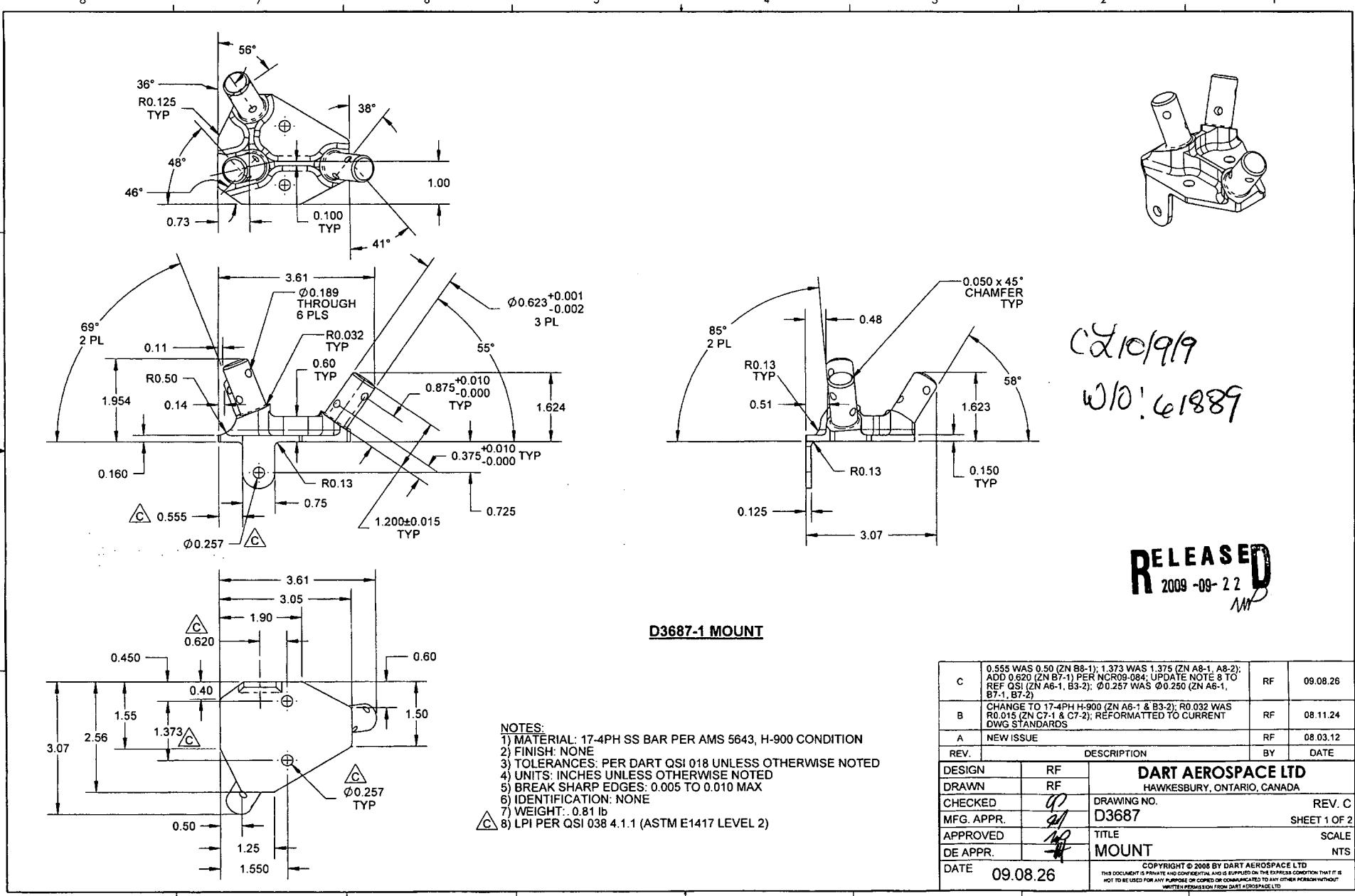
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



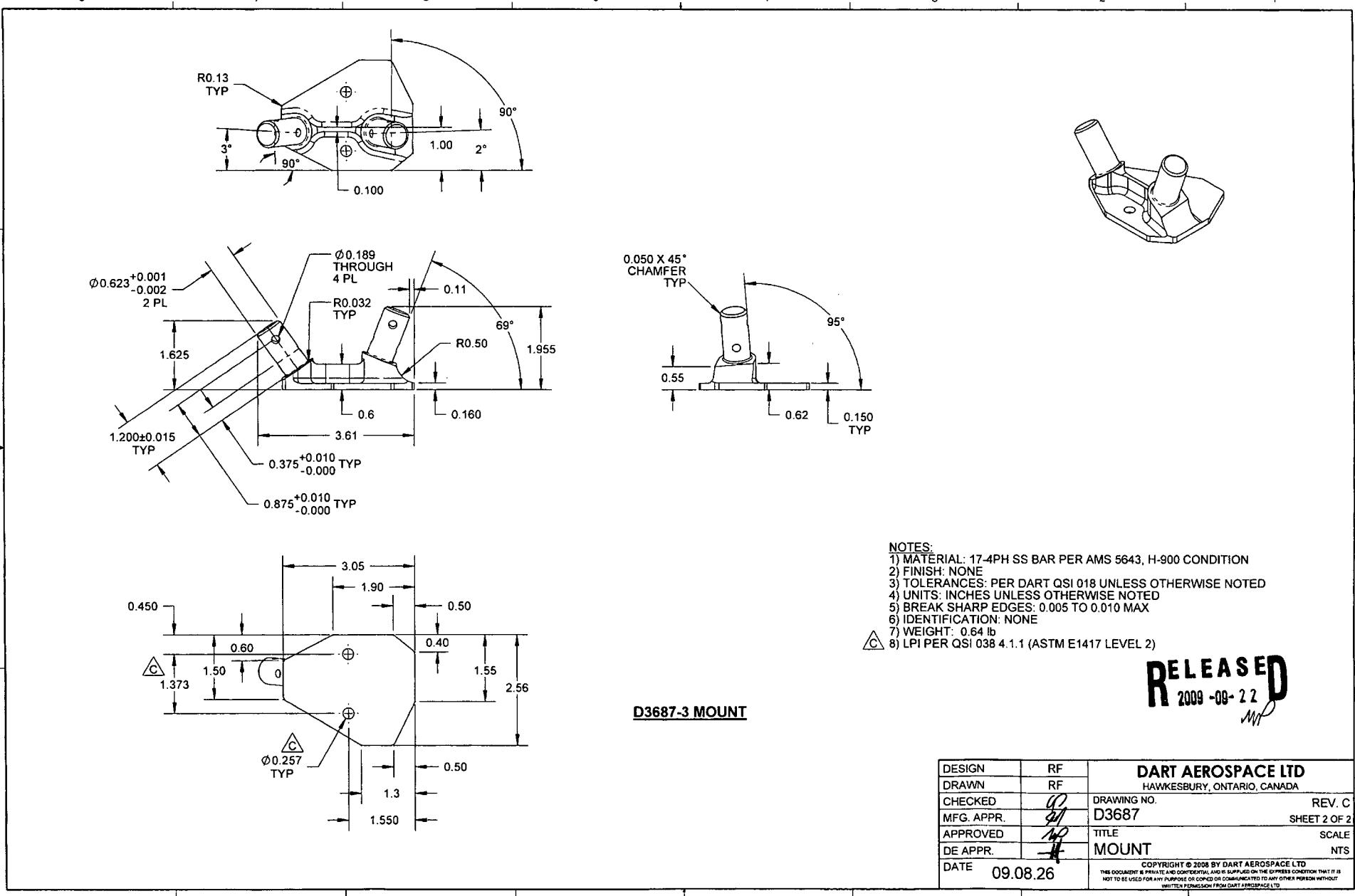
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

July 31, 2009 2:32:03 PM

Page 1

Work Order ID: 51097



Parent Item: D3687-1RevB



Parent Item Name: MOUNT

Start Date: 8/03/09

Required Date: 8/11/09

Comments:

Start Qty: 25.00

Required Qty: 25.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1748H- 1190033.937X4.750		Purchased	No			100	f	3.0000	8.3333			

174SS Bar 11900-3.937x4.750

D3687-1P



MOUNT

Purchased

No

105

Each

0.0000 25.0000



mc 09-09-29 - 2

Reff/29 (4)

REFERENCE ONLY

REFERENCE ONLY



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO12542

Purchase Order Date 9/09/10  
PO Print Date 9/09/10

Page Number 1 of 1

Order From :

VC-GLO001

GLOBUS PRECISION INC.  
36 COLONNADE RD. N.  
NEPEAN, ON K2E 7J6  
CA

Contact Name  
Vendor Phone 613 226 1579  
Vendor Fax 613 226 1719  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
*Oct 9/10*

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3687-1P	MOUNT	10/08/10 Yes	5.00 Each	Purolator ground	\$400.0000	\$2,000.00

**Special Inst:** MACHINE AS PER DWG D3687 REV. C  
B61889  
MATERIAL: 174PH-H900 BAR 3.937 X  
4.750 M112374  
SUPPLIED BY DART

2	D3687-3P	MOUNT	10/08/10 Yes	5.00 Each	Purolator ground	\$326.4200	\$1,632.10
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**Special Inst:** MACHINE AS PER DWG D3687 REV. C  
B61890  
MATERIAL AS ABOVE

**PO Total:** \$3,632.10

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

No substitution or deviation without consent.  
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1

Change Date: 9/09/10



**GLOBUS**  
PRECISION INC.

36 Colonnade Road N.  
Ottawa, Ontario K2E 7J6  
Tel: (613) 226-1579  
Fax: (613) 226-1719

# Invoice

DATE	INVOICE NO.
10/19/2010	18119

BILL TO			SHIP TO							
P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB					
12542	Net 30 Days	10/19/2010	FedEx	211	Globus					
QTY	DESCRIPTION									
5	D-3687-1P Mount									
5	D-3687-3P Mount									
Business Number: 102122058										
Total PST										

ALL PARTS AND MATERIALS LISTED HAVE BEEN  
INSPECTED AND APPROVED IN CONFORMANCE WITH DRAWINGS  
AND SPECIFICATIONS AS FURNISHED BY THE CONTRACTOR'S SPECIFICATIONS



WHITE = Original  
BLUE = C of C  
YELLOW = Packing Slip

HST

TOTAL

\$0.00

## Receiving Report

Date: 09/08/06

Batch No: M112374

Supplier: Unigear

Dart P/O: 10117

Packing Slip: Yes / No /  
 Invoice: Yes / No /  
 Receipt: Cash / Cr /

Release Note Attached: Yes / No / N/A /  
 Waybill Attached: Yes / No /  
 Shipment Complete: Yes / No / N/A /  
 QC6 Inspection S 09/08/21 N/A /  
 Work Order 09/08/21 N/A /

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 CZ

Production/Admin:

Location       

Date 08/09/06

Received/Costing RCP 10117

Initial CZ



Magna Stainless  
5775 Kieran St, Saint-Laurent QC H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 I014724

SOLD TO:

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY , ON  
K6A 1K7

RECEIVED

JUL 31 2009

SHIP TO:

METCOR  
560 BOUL ARTHUR SAUVE  
SAINT-EUSTACHE, QC  
J7R 5A8

MTR: Y

INVOICE DATE:	07/27/09
ORDER DATE:	07/22/09
SHIP DATE:	07/27/09
ORDER NUMBER:	W016184
PURCHASE ORDER:	P010117

Currency	Sales Person		Ship Via	F.O.B.	Terms		
CANADIAN DOLLARS	ERYCK BLAIS		NIR: R-557065-1	PREPAID	NET 30 DAYS		
Ln.	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
		2	PC	STAINLESS - LB 17-4 PH 3.937 X 4.750 X 9' L029745 2 PC/1,201 LB PLEASE CUT BAR IN HALF	2 UN	4,310.00	8,620.00
		4	PC	STAINLESS ROUNDS SRB 17-4 ANN 1" x R/L L025718 12'7" 4 PC/134 LB PLEASE CUT ALL INTO 4' LG PIECES PLUS DROPS MUST BE SPEC AMS 5643	4 UN	135.00	540.00
		2	PC	SRB 17-4 ANN 1-3/8" x R/L L029746 12'5" 2 PC/124 LB PLEASE CUT ALL INTO 4' LG PIECES PLUS DROPS MUST BE SPEC AMS 5643	2 UN	280.00	560.00

07/28/09 13:22:01

Merchandise:	9,720.00
Surcharges:	
No Tax Costs:	
GST	486.00
PSTQ	765.45
Total Due:	10,971.45

Q.S.T. # 1213236471  
G.S.T. # 881565899 RT0001

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

## Purchase Order Receipt Listing

Page 1 of 1

August 19, 2009 3:06:10 PM

All amounts are calculated in domestic currency.

All Vendors PO ID PO10117 All Receipt Dates All Line Item Types  
 All Item ID/GL/WOs All Rec. Employees All Currencies  
 Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date/ Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO10117	1		M174PH- H900B3.937X4.750	f	7/27/09	8/19/09	19.0277	\$478.89	0.0000	0	\$9,112.18
CAD	No		17-4SS Bar H900- 3.937x4.750	f	18.0000	LAVO01		\$9,112.18	0.0000	0	
			112374								
	2		M174PH- H900R1.000	f	7/22/09	8/19/09	44.0000	\$13.50	0.0000	0	\$594.00
	No		17-4SS H900 ROUND BAR 1.00	f	40.0000	LAVO01		\$594.00	0.0000	0	
			112374								
	3		M174PH- H900R1.375	f	7/22/09	8/19/09	24.0000	\$28.00	0.0000	0	\$672.00
	No		17-4 SS H900 ROUND BAR 1.375	f	20.0000	LAVO01		\$672.00	0.0000	0	
			112374								

Total Received Quantity:	87.0277
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$10,378.18
Total Balance Due Quantity:	0.0000

**MagnaStainless**1775 de la Salle, Saint-Laurier, Quebec J4S 0A3  
Phone (514) 335-2202 Fax (514) 335-3105**PACKING LIST**

1014724

Page 1 of 1

**SPECIAL INSTRUCTIONS**SOLD TO:  
DART AEROSPACE INC.  
11270 LASERGREEN STREETSHIP TO:  
METACOR  
1560 BOUL AVENUE  
ARTHUR, SAINT-JEANHAWKSBURY INDUSTRIAL PARK  
1000 HAWKSBURY RD  
HAWKSBURY, ONTARIO  
N0G 1L0COMPTON INDUSTRIES LTD  
1000 COMPTON AVENUE  
OTTAWA, ONTARIO  
K2B 5P4

CREDIT CARD NUMBER:

NAME:

CANADIAN ELECTRICAL

PROJECT NUMBER:

WEEKLY ORDER

ITEM NUMBER:

W014724

SHIPMENT NUMBER:

NET 30 DAYS

DATE SHIPPED:

INVOICE NO. 557065

DATE REQUIRED:

2009/08/27

2009/08/27

2009/08/27

2009/08/27

2009/08/27

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO10117

Purchase Order Date 7/22/09  
PO Print Date 7/22/09

Page Number 1 of 1

Order From :

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

VC-MAG002

Contact Name

Vendor Phone 800 363 6646  
Vendor Fax 514 339 1105

Buyer

Requisition Nbr  
Tax Resale Nbr 10127-2607

Vendor Account Nbr

Terms Net 30  
Currency CAD  
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M174PH-H900B3.937X4.750 <i>1209108107</i>	17-4SS Bar H900- 3.937x4.750	7/27/09 <i>7/09/09</i>	18.00 <i>19.25' total</i> Yes	Epic collect <i>Recd 19.3333 f</i>	\$478.8900	\$8,620.02
2	M174PH-H900R1.000 <i>req'd 48 1209108107</i>	17-4SS H900 ROUND BAR 1.00	7/22/09 <i>7/22/09</i>	40.00 <i>44' total</i> Yes	Epic collect <i>f</i>	\$13.5000	\$540.00
3	M174PH-H900R1.375 <i>req'd 24 1209108107</i>	17-4 SS H900 ROUND BAR 1.375	7/22/09 <i>7/24' total</i>	20.00 <i>-</i> Yes	Epic collect <i>f</i>	\$28.0000	\$560.00

Special Inst: ALL ABOVE: 17-4PH cond. H900  
PER AMS 5643  
PLEASE SHIP ALL ABOVE TO  
METCOR INC  
560 BOUL. ARTHUR SAUVE  
SAINT-EUSTACHE, QC  
J7R 5A8 (450-491-5498)  
SHIP VIA EPIC EXPRESS OUR  
ACCT # 4300450343

POSITIVE RECALL

EFFECTIVE 7/22/09 AUTH DL  
RELEASED WP DATE 7/22/09



PO Total:

\$9,720.02

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 2

Change Date: 7/22/09

**L Lacelle**

---

**From:** Eryck Blais [mailto:[eblaiss@magnastainless.com](mailto:eblaiss@magnastainless.com)]  
**Sent:** July 22, 2009 1:14 PM  
**To:** 'L Lacelle'  
**Subject:** RE: rfq

THANK YOU  
ERYCK

---

**From:** L Lacelle [mailto:[llacelle@dartaero.com](mailto:llacelle@dartaero.com)]  
**Sent:** Wednesday, July 22, 2009 1:09 PM  
**To:** Eryck Blais  
**Subject:** RE: rfq

Hi Eryck,

We will take the 2 x 9' (3.937 x 4.750) THAT IS O.K.  
We also require 17-4PH H900 round bar 1.375, approx 20' 2 PCS 280.00 NOT H900  
Please advise asap...and could you ship this stuff to metcor tomorrow? I CAN SHIP TO METCOR ON MONDAY  
NEED ORDER TODAY BY 2:30 MAT'L IS IN ARE TOR BRANCH

Thx  
Linda

---

**From:** Eryck Blais [mailto:[eblaiss@magnastainless.com](mailto:eblaiss@magnastainless.com)]  
**Sent:** July 22, 2009 9:38 AM  
**To:** 'L Lacelle'  
**Subject:** RE: rfq

HI LINDA

NO IT DOES NOT MARK H900 YOU HAVE TO SEND IT TO METCOR  
ERYCK

---

**From:** L Lacelle [mailto:[llacelle@dartaero.com](mailto:llacelle@dartaero.com)]  
**Sent:** Wednesday, July 22, 2009 9:24 AM  
**To:** Eryck Blais  
**Subject:** RE: rfq

Does the bar read H900 on it? They did last time? Otherwise please ship to metcor  
Thx  
LL

---

**From:** Eryck Blais [mailto:[eblaiss@magnastainless.com](mailto:eblaiss@magnastainless.com)]  
**Sent:** July 22, 2009 9:18 AM  
**To:** 'L Lacelle'  
**Subject:** RE: rfq

YES IT WOULD BE FASTER WE WOULD SHIP IT FOR YOU AT METCOR  
ERYCK

---

**From:** L Lacelle [mailto:[llacelle@dartaero.com](mailto:llacelle@dartaero.com)]  
**Sent:** Wednesday, July 22, 2009 9:09 AM  
**To:** Eryck Blais  
**Subject:** RE: rfq

IF IT'S FAST YES.

*Cut to 4'*

---

**From:** Eryck Blais [mailto:[ebblais@magnastainless.com](mailto:ebblais@magnastainless.com)]  
**Sent:** July 22, 2009 9:03 AM  
**To:** 'L Lacelle'  
**Subject:** RE: rfq

GOOD MORNING LINDA

ON THE H900 CHANTAL WOULD TELL US TO SHIP AT METCOR AND YOU WOULD TAKE CARE OF THE  
HEATING PROCESS TO H900.  
THANK YOU ERYCK

---

**From:** L Lacelle [mailto:[llacelle@dartaero.com](mailto:llacelle@dartaero.com)]  
**Sent:** Tuesday, July 21, 2009 4:09 PM  
**To:** Eryck Blais  
**Subject:** rfq

Please advise price and delivery on:

40' x 17-4PH bar 3.937 x 4.750 OFFER 2 PCS 9' \$4310.00 EACH 1 PC 4' \$1915.00 EACH AND 2 PCS 12'  
LONG 5" SQ \$8095.00 EACH  
40' x 17-4PH round bar 1.000 4 PCS 135.00 EACH STK  
10' x 17-4PH bar .250 x 4.00 1 PC 225.00 EACH 5-7 DAYS  
10' x 17-4PH bar .375 x 1.00 1 PC 115.00 EACH 5-7 DAYS  
12' x 2024-T3 hex 1.375 1 PC \$385.00 EACH 7-10 Days  
12' x 2024-T3 round bar 1.750 1 PC 255.00 EACH 5-7 DAYS  
128sf x 2024-T3 sheet .080 3 PCS 345.00 EACH 5-7 DAYS  
128sf x 2024-T3 sheet .040 3 PCS 285.00 EACH 5-7 DAYS  
20' x 303 bar 1.500 x 3.000 2 PCS \$1165.00 EACH 5-7 DAYS  
40' x 303 round bar .500 4 PCS \$17.00 EACH STK  
40' x 304 bar .500 x 2.500 4 PCS 215.00 EACH TOR  
10' x 304 bar .625 x 3.00 1 PC 310.00 EACH TOR  
10' x 304 bar 1.750 x 1.750 \$685.00 EACH STK  
64sf x 304 sheet 12ga 2 PCS 260.00 EACH STK  
192sf x 304 sheet 16ga 6 PCS 158.00 EACH STK

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd

# Metcor Inc.

Metcor Inc.  
560, boul. Arthur-Sauvé  
St-Eustache (Québec) J7R 5A8  
Tél.: (450) 473-1884  
Fax Administration: (450) 491-5498  
Fax Production : (450) 491-6454

## Rapport d'inspection

Order	Load
149974	1

Customer 215  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY  
ON K6A 1K7

Shipped To:  
DART AEROSPACE  
1270 ABERDEEN  
HAWKESBURY  
ON K6A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Matié Heat Code	Lot Number
10128		17-4PH		

### PROCESSING SPECIFICATIONS

AGE HARDEN

CONDITION H8001

SAE AMS 2758/3 REV E

Requirement	Specified	Tests Performed	Test Results
HARDNESS	40 - 47 HRC	28	43 - 45 HRC

Quantity	Weight	Part Number / Part Description
28	1447	BARRE RONDE 8 BARRES DE 7" + 18 BARRES DE 48" BAR 1" & 1.375" BARRE CARREE 4 BARRES DE 68" BAR 3.937 X 4.758 1 PALETTE

### COMMENTS

INSPECTOR:



DATE: 2009-08-04

# **FACSIMILE TRANSMITTAL**

**MAGNA  
INOXYDABLE INC.**

**TO/À:** Chantal **(613)**  
**FAX #:** 632-1053

**CO:** Dart Aerospace **DATE:** Aug. 20/09

**RE:** PO # 10117 **PAGES:** 6 + COVER

**FROM/DE:** **BARRY MARTIN**

## **QUALITY MANAGER/GÉRANT À LA QUALITÉ**

**PHONE: (514) 339-1211**

**FAX: (514) 335-2202**

E-MAIL: [bmartin@magnastainless.com](mailto:bmartin@magnastainless.com)

**5775 Rue Kieran St-Laurent Quebec H4S 0A3 TEL: (514) 339-1211 1 (800) 363-6646**



**Acciaierie  
Valbruna s.p.a.**



39100 VICENZA (Italia) - Viale della scienza, 25 z.i.  
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4  
Città / Distretto/Purchase/City  
**VALBRUNA CANADA LTD**  
8724 HOLGATE CRESCENT  
CDN-MILTON, ONT L5T 5Z1-CAN

Produttore: **ACCIAIERIE VALBRUNA S.P.A.**  
Non interferire con l'uso produttivo

**Oggello Prove: Polished Annealed Peeted  
Prüfgegenstand nach Inspektion abgestoßen**

19. *Leucosia* *leucostoma* *leucostoma*

**Specifiche:**  
Anforderungen / Requisitos / Exigencias  
**VAL CANADA 2 630 A**  
**ASTM A564 2004 S17400**  
**(D) SEC.II PT.A 2007 EDITION**

Dual Name: T-630

Marca: V17A

**FERRITE DELTA %**

## Analisi chimica

Annealing temperature 1922 deg. F for 1 H / air.

Macro etch test: satisfactory.

Produced without class I-II Ozone depleting substances

Material Is DFARS Compliant

Vicenza, 09/01/09 Uscita <i>(RICOH FACET)</i>	<i>Il collaboratore di stabilimento / der Werkssachverständige / Works inspector / L'agent d'usine</i> <i>M.Rizzotto</i>	Pagina - 1 di 2
---	---	-----------------

# Acciaierie Valbruna S.p.A.



36100 VICENZA (Italia) - Viale della scienza, 25 z.I.  
Stab.: 39100 BOLZANO (Italia) - Via A. Volta, 4

Ciante / Ansteller/Purchaser/Cliant  
VALBRUNA CANADA LTD  
8724 HOLGATE CRESCENT  
CDN-MILTON, ONT L5T 5Z1-CAN

Produttore: ACCIAIERIE VALBRUNA S.P.A.  
Hendella/Name/Name du producteur

Oggetto Prove: Polished Annealed Peeled  
Hügelgestraukter Repeckad/Ferriage

Aviso di Spedizione: D-VI09000237  
Uferanzeige/Reise-Nr. L.

Ordine nr: 808001998 STOCK  
Bestell-Nr./Your order/Commande

Tipo di Elaborazione: E+AOD  
Erhitzungskontrolle/Control processus/d'elaboration

## CERTIFICATO DI COLLAUDO ABNAHMEPRUEFZEUGNIS INSPECTION CERTIFICATE CERTIFICAT DE RECEPTION EN 10204 (2005), 3.1

Certificato nr: MEST706471/2009/  
Prüfung/Test/Essai

Conforma ordine nr: EI08009960  
Wahld-Der Order/Malet.

Marchio di Fabbbrica:  
Zeichen des Herstellers  
Flido mark.  
Sigle de l' usine producteur



Punzone del Collaudatore:  
Stampo des Prüfmeisters der Abgen  
Impender e stampa/Stampen du l'assayeur



Molto and manufactured in Italy No welding or weld repair Material free from Mercury or radio-activity contamination  
The Quality Management System is Certified acc. Pressure Equipment Directive (97/23/EC) Annex I, s.4.3 by TÜV and LLOYD'S

Vicenza, 09/01/09  
VC0012  
Mod. MCER0

Il collaudatore di stabilimento / der Werkstattvorständige / Works Inspector / L' agent d' usine  
M.Rizzotto

pagina - 2 di 2

**CERTIFICATE OF TESTS**  
CERT SERIAL# 000681003



Talley Metals Technology, Inc.  
205 Talley Metal Lane  
McBee, SC 29101 Tel: (510) 208-2000 (800) 338-4592

01/30/09  
CUSTOMER/BESTELLER/CLIENT

**ABNAHMEPRUEFZEUGNIS**

**CERTIFICAT DE CONTROLE**

- THE RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR ENTRIES ON THIS DOCUMENT MAY BE PUNISHED AS A FELONY UNDER FEDERAL STATUTES INCLUDING FEDERAL LAW, TITLE 18, CHAPTER 47.
- THE VALUES AND OTHER TECHNICAL DATA REPRESENT THE RESULTS OF ANALYSES AND TESTS MADE ON SAMPLES COLLECTED FROM THE TOTAL LOT. ORIGINAL DATA RECORDS CAN BE TRACED BY REFERENCE TO THE CARPENTER ORDER NUMBER.
- MATERIAL IS MANUFACTURED FREE FROM MERCURY, RADIUM, ALPHA AND GAMMA SOURCE CONTAMINATION.
- THIS DOCUMENT SHALL NOT BE REPRODUCED, EXCEPT IN FULL, WITHOUT THE WRITTEN CONSENT OF CARPENTER TECHNOLOGY CORPORATION.

69867 2/2  
SELLER/VERKAUFER/VENDEUR PAGE 1 OF 2

**ASA ALLOYS DIV./ CSM INC.**  
4311-92ND AVE.  
EDMONTON, ALBERTA  
T6B 3M7 ,CANADA

**TALLEY METALS TECH, INC.**  
ACCOUNTS PAYABLE  
P. O. BOX 2498  
HARTSVILLE ,SC 29551

CUSTOMER ORDER NO./BESTELL-NR./N° DE COMMANDE	CARPENTER NO./WERKS-NR./N° DE REFERENCE INTERNE	DATE/DATUM/DATE	WEIGHT/GEWICHT/POIDS
077548-AG	TLY952201 L14967	01/30/09	992.000

HEAT NUMBER/SCHMELZE-NR./N° DE COULEE: G15282

PRODUCT DESCRIPTION: TYPE 17-4 SOLUTION ANNEALED COLD FINISH

SPECIFICATION: TALLEY 17-4T3A CAP OF H900  
-----  
AMS 2303 REV E (10/ /01)  
AMS 2315 REV F (01/ /08)  
AMS 5643 REV R (02/ /08) (EXCEPT CD ROUND CHEM & MECH PROPS  
ONLY)  
ASTM-A484-06B  
ASTM-A564-04  
ASME-SA564 2007 EDITION

SIZE 1.375000 IN. ( 34.93 MM) RD BAR

PRIMARY HEAT CHEMISTRY(WT%): (TEST METHOD IS SHOWN IN PARENTHESIS)

C (COM)	MN(XRF)	SI(XRF)	P (XRF)	S (COM)	CR(XRF)
0.029	0.86	0.40	0.019	0.026	15.36
NI (XRF)	MO(XRF)	CU(XRF)	N (FUS)	CB(XRF)	TA(XRF)
4.30	0.24	3.76	0.028	0.24	LT .01
CB+TA					
0.25					

THIS HEAT MELTED BY THE ARC/AOD PROCESSES  
THIS MATERIAL WAS MANUFACTURED IN ACCORDANCE WITH CARPENTER SPECIALTY ALLOYS  
OPERATIONS QUALITY PROGRAM MANUAL REVISION 27, DATED 1/08.

MILL HEAT TREATMENT:  
TYPE SOL ANL  
TEMP 1900F ( 1037C)  
TIME (CONT FCE) 1.46 HOURS  
QUENCH AIR

DISCS MACROETCHED AND APPROVED

HARDNESS AS SHIPPED, HBW - 341

(MIDRADIUS)

MICROSTRUCTURE - FERRITE - NONE  
MAGNETIC PARTICLE: FREQUENCY = 0 / SEVERITY = 0

CONTINUED ON NEXT PAGE

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CERTIFICATE OF TESTS  
CERT SERIAL# 000681003



Talley Metals Technology, Inc.  
205 Talley Metals Lane  
McBee, SC. 29101 Tel: (610) 208-2000 (800) 338-4592

01/30/09

CUSTOMER/RESELLER/CLIENT

ABNAHMEPRUEFZEUGNIS

CERTIFICAT DE CONTROLE

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SELLER/VERKAUFER/VENDEUR PAGE 2 OF 2

ASA ALLOYS DIV./ CSM INC.  
4311-92ND AVE.  
EDMONTON, ALBERTA  
T6B 3M7 ,CANADA

TALLEY METALS TECH, INC.  
ACCOUNTS PAYABLE  
P. O. BOX 2498  
HARTSVILLE ,SC 29551

CUSTOMER ORDER NO./BESTELL-NR./N° DE COMMANDE	CARPENTER NO./WERKS-NR./N° DE REFERENCE INTERNE	DATE/DATUM/DATE	WEIGHT/GEWICHT/POIDS
077548-AG	TLY952201 L14967	01/30/09	992.000

HEAT NUMBER / SCHMELZE-NR. / N° DE COULEE:	G15282
CAPABILITY	
900 F( 482 C), 01 HR	AIR COOL
YIELD STRENGTH, (0.20 %) KSI(MPA)	186.0 { 1282}
TENSILE STRENGTH, KSI(MPA)	207.0 { 1427}
ELONGATION IN 2.00", %	13.0
REDUCTION OF AREA, %	46.0
HARDNESS , HBW	409.0

(CONVERTED FROM TENSILE STRENGTH)

NO WELD REPAIR PERFORMED  
MATERIAL PRODUCED ON THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A.  
MATERIAL HAS BEEN MELTED IN USA OR QUALIFYING COUNTRY TO DFARS REQUIREMENTS 252.225-7014 WITH ALTERNATE 1 FOR QUALIFYING COUNTRY 225.872.1.  
WE HEREBY CERTIFY THAT THE ABOVE TEST DATA ARE IN ACCORDANCE WITH THE PURCHASE ORDER AND SPECIFICATION REQUIREMENTS. CERTIFICATE OF TEST IS PREPARED IN ACCORDANCE WITH PARAGRAPH 3.1B OF EN 10204(DIN50049)

STEPHANIE E. MCCULLUM  
QUALITY ASSURANCE ENGINEER  
CARPENTER TECHNOLOGY CORPORATION

*Stephanie E. McCullum*

This certification is made to the customer printed on this form. Carpenter neither makes, nor assumes responsibility for, any representation or certification to other parties.  
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Ce certificat est uniquement valable pour le client dont le nom est inscrit sur ce formulaire. Carpenter n'assume pas de responsabilité pour une certification vis-à-vis d'une tierce personne.



## LIQUID PENETRANT TEST REPORT

P- 05491

CLIENT

ATTENTION

ADDRESS

PROJECT

ITEM(S) EXAMINED

JOB DESCRIPTION

PROCEDURE NO. LT-003 REV./DATE DEC08

PAGE 1 OF 1

DATE

NOV-23-2010

TIME

AM

PM

ACUREN JOB NO.

188-10-0871

PO/WO NO.

V29871

WORK LOCATION

AS ADDRESS

ACCEPTANCE STD.

REV./DATE

DART AEROSPACE  
LINDA HACHELIE / CHANTALE LIPPI  
1270, ABERDEEN ST.  
HALIFAX, NS

WET FLUORESCENT PENETRANT TESTING ON "CROSSTUBES" &amp; "MOUNT"

SEE W.O.# BELOW IN RESULTS

ART NO.	MATERIAL	THICKNESS
SCOPE	PERFORMED A WET FLUORESCENT INSPECTION BY LIQUID PENETRANT ON 100% OF THE EXTERNAL SURFACE	

## TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
MANUFACTURER	MAGNAFLUX		BLACK LIGHT S/N 13790	OUTPUT > 1000 μW/cm <sup>2</sup>	AMBIENT < 2 fc
PENETRANT	ZL-67	MINIMUM Dwell TIME	10 MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE	
PENETRANT REMOVER	H <sub>2</sub> O	MINIMUM DRY TIME	>10 MIN.	OTHER	
DEVELOPER	SKD-52	MINIMUM Dwell TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE FEB05-2011
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

## TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F		

RESULTS- (  METRIC  IMPERIAL)

ITEM	COMMENTS	ACCEPTED
1	CROSSTUBE - W.O. ID 63537	✓
2	CROSSTUBE - W.O. ID 63528	✓
3	CROSSTUBE - W.O. ID 63533	✓
4	CROSSTUBE - W.O. ID 63539	✓
5	CROSSTUBE - W.O. ID 63744	✓
6	CROSSTUBE - W.O. ID 63745	✓
7	4X MOUNT(S) - W.O. ID 61889	✓

**CROSSTUBE AFT**

ITEM ID: D206-667-203 (ITEM# 1, 2)

ITEM ID: D210-664-201 (ITEM# 3, 4)

ITEM ID: D210-664-101 (ITEM# 5, 6)

**CROSSTUBE FWD**

— MOUNT —

ITEM ID: D3687-1 (ITEM# 7)

10-11-73

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood at all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as presentations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

in performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE

Matt Morosch

Matthew Morosch

DTR # E63039

TECHNICIAN (SIGNATURE):

John DesRosiers

SIGNATURE

REPORT

NAME (PRINT):

CGSB LEVEL 2 SNT LEVEL 2

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